

2

Work Order ID 164772

Friday, July 28, 2017 11:58:23 AM

164772

Page 1

Item ID: D3914-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Long Basket Lid Assembly (350)
Start Date: 8/3/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/1/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: Wm JS Date: 7/7/28 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	D								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 3136920 0.00

100

Large Fab

Large Fab

Large Fab

Memo

2.77

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

14 16 17-8-16

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

3 1703.22 DAS
9
9-89

2

Work Order ID 164772

Friday, July 28, 2017 11:58:23 AM

164772

Page 2

Item ID: D3914-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Long Basket Lid Assembly (350)
Start Date: 8/3/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/1/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.02

Quality Control

-Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per
QSI 044 6.4

① 17-03-22 DAS 9 9-89

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1-Powder coat Black Sandtex (4.3.5.7) per Dart QSI 005 4.3

2-Mask this area prior to finish View E-E

3-Mask holes prior to finish Detail D

4-START TIME: 7:25

OVEN TEMPERATURE: 000

FINISH TIME: 8:55

1 17-08-30 DAS 34 9-89

Work Order ID 164772

Friday, July 28, 2017 11:58:23 AM

164772

Page 3

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Lid Assembly (350)
Start Date: 8/3/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/1/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135	QC3- Inspect Part Finish	0.00							
135									
QC	Memo	0.00							
Quality Control									
140	Wing Walk as per dwg QSI005 4.4 Batch <u>1137947</u>	0.00							
140									
HandFinish	Memo	0.66							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg.								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.01							
Quality Control									

DAS 15 9-89
201708/31
BEB.
DAS 16 9-89
17/09/01

Work Order ID 164772

Friday, July 28, 2017 11:58:23 AM

164772

Page 4

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Lid Assembly (350)
Start Date: 8/3/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/1/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>W/O</u>	0.00							
160									
Packaging	Memo	0.01				<u>1K</u>			<u>17/09/01</u>
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							<u>17/9/8</u>
Quality Control									

DAS
21
9-89WY SEP 06 2017

Picklist Print

Friday, July 28, 2017 11:58:23 AM

Page 1

Work Order ID: 164772

164772

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/3/2017

Required Date: 9/1/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS
PER DWG REV.pc1 DD VERF:JLM IPP REV:D 13.06.21 DWG
REV.C DD VERF:JFS IPP Rev.E 17.06.12 As per Dwg.Rev.D DP
VerifyDD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3914-1 Rib		Manufactured	No			100	Each	4.0000	2	2			
** 164129 x 2 D.M.L 2017-8-10													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				4					
				163870				4					
✓ D3914-7 Rib		Manufactured	No			100	Each	0.0000	2	2			
** 163045 x 2 D.M.L 2017-8-10													
✓ D4018-5 Rib		Manufactured	No			100	Each	12.0000	9	9			
** 164835 x 9 D.M.L 2017-8-10													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				12					
				163335				12					
✓ D4035-043 Lid Rib Assembly, Aft (350 Basket)		Manufactured	No			100	Each	2.0000	2	2			
** 163326 x 2 D.M.L 2017-8-10													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				2					
				163958				2					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
		OTHER :																							

Picklist Print

Friday, July 28, 2017 11:58:23 AM

Page 2

Work Order ID: 164772

164772

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/3/2017

Required Date: 9/1/2017

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

64.0000

2 2

D2581

Mounting Bracket

** 163743 x 2 D.M.L 2017-8-10

Location

Loc Qty

Loc Code

WA004

64

161800

10

162923

30

163743

24

D4016-3

Manufactured No

100

Each

58.0000

3 3

D4016-3

Hinge Half, Lid

** 160518 x 3 D.M.L 2017-8-10

Location

Loc Qty

Loc Code

WA004

58

159570

8

160518

50

D4020-5

Manufactured No

100

Each

2.0000

1 1

D4020-5

Mesh (350 Basket Long, Lid)

**

Location

Loc Qty

Loc Code

WA004

2

164086

2

D4021-3

Manufactured No

100

Each

8.0000

1 1

D4021-3

Data Plate

** 160720 x 1 D.M.L 2017-8-10

Location

Loc Qty

Loc Code

WA004

8

160720

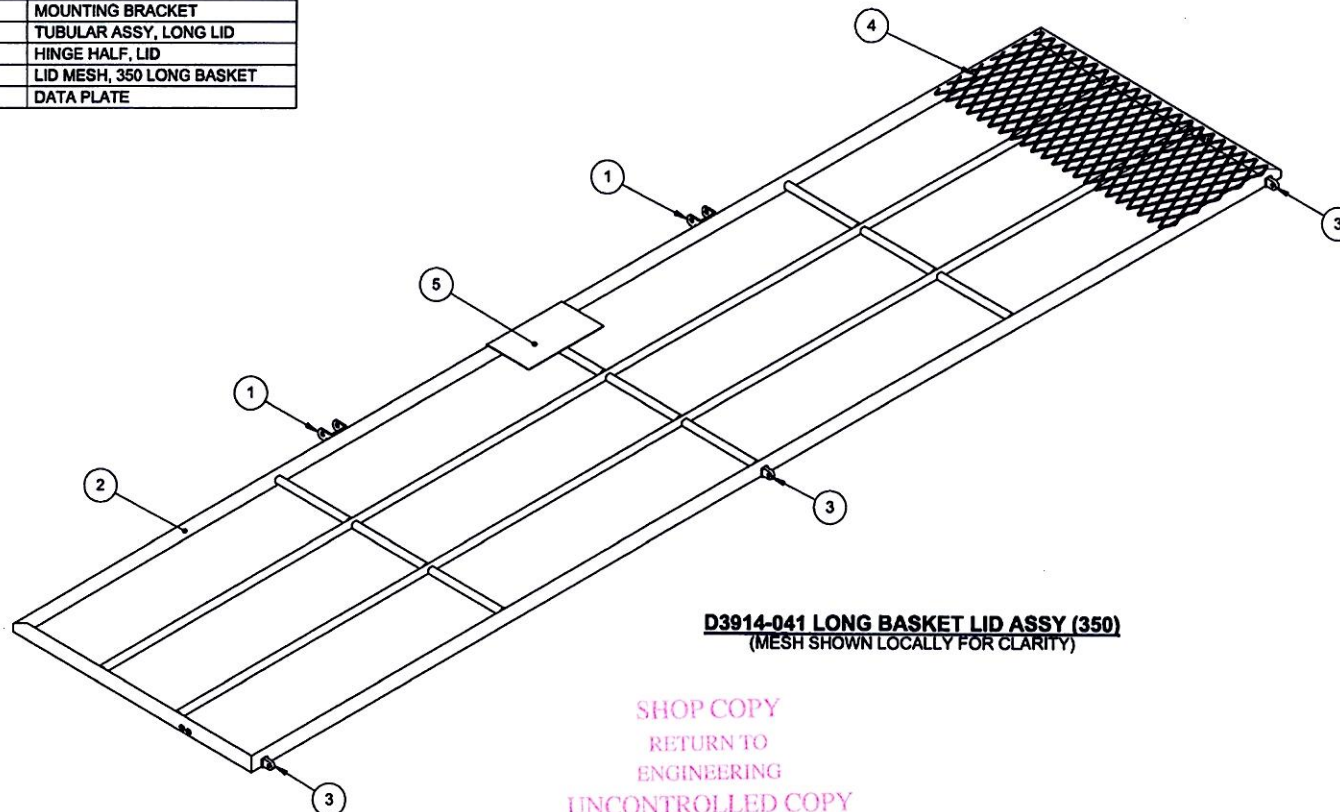
8

Friday, July 28, 2017 11:58:23 AM

Shop Packet Print

Page 2

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	1	D3914-101	TUBULAR ASSY, LONG LID
3	3	D4016-3	HINGE HALF, LID
4	1	D4020-5	LID MESH, 350 LONG BASKET
5	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164772

UN 17/1/20

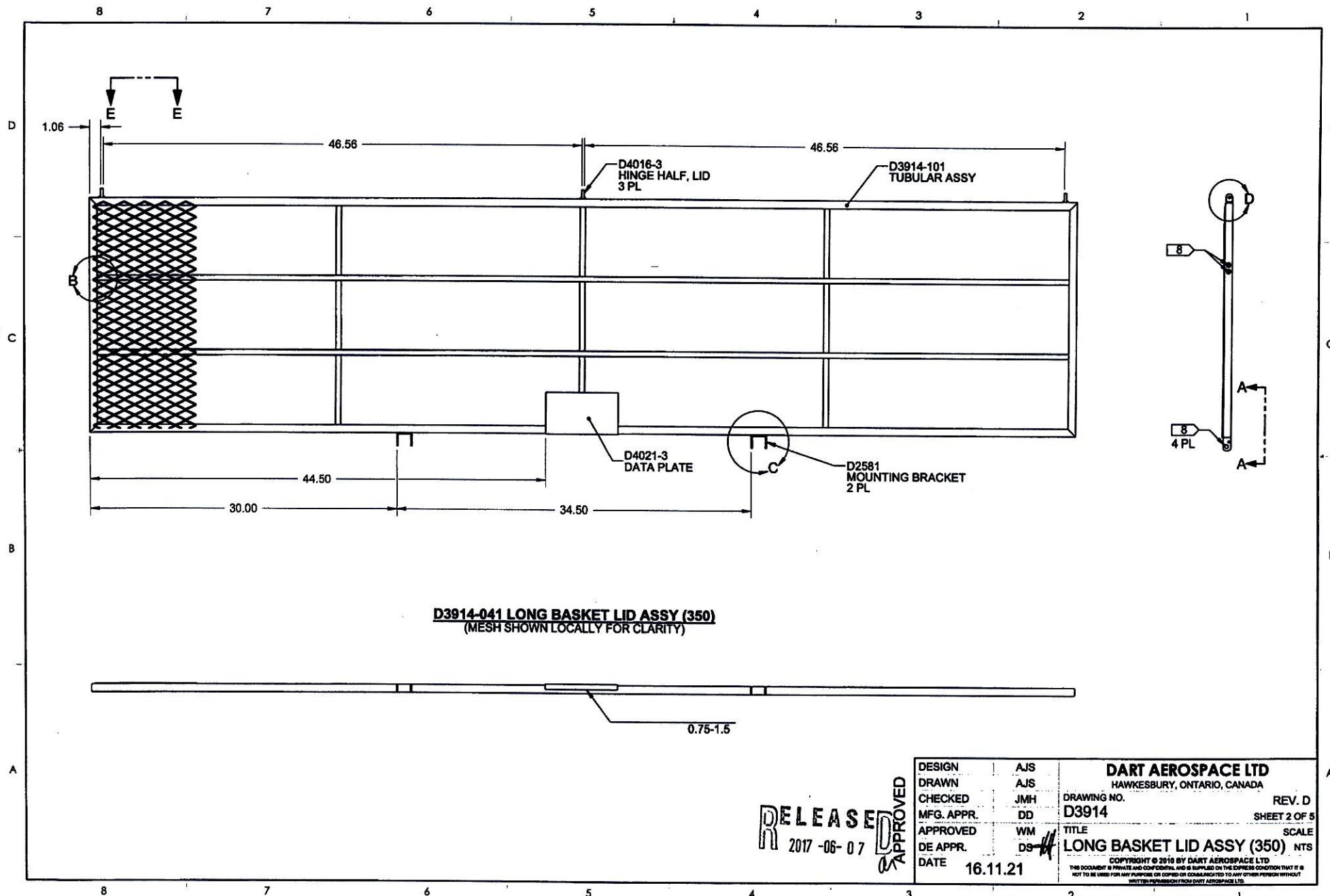
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004
- 10) MASK THIS AREA PRIOR TO FINISH

D	SHEET 1: UPDATED NOTE 6 ADDED NOTE 10. D2728-3 DELETED. SHEET 2: SECTION AND VIEW LETTERS UPDATED. ADDED VIEW E-E. (PAR15-418)	AJS	18.11.21
C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROFORM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4088-210. UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

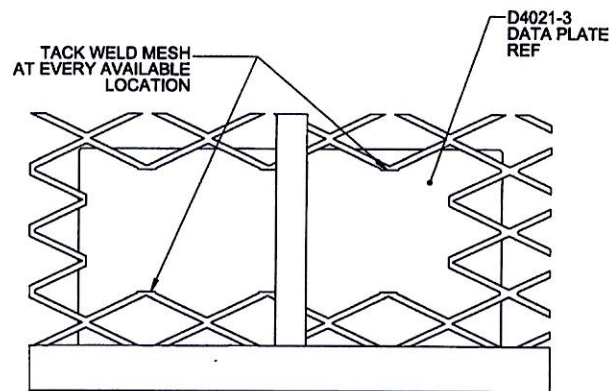
RELEASED
2017-06-07
EN 17-580



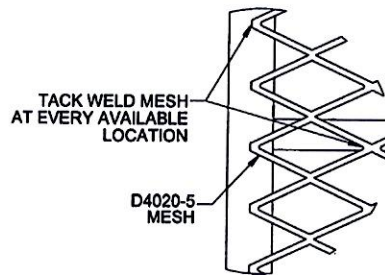
8 7 6 5 4 3 2 1

D

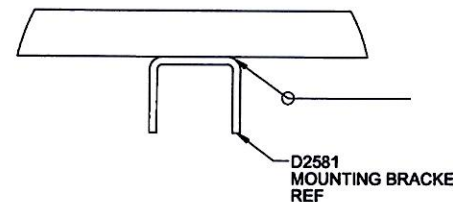
D



VIEW A-A
SCALE 4X



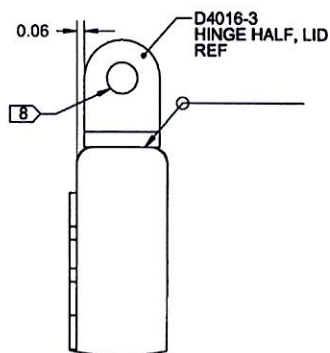
DETAIL B
SCALE 4X



DETAIL C
SCALE 4X
2 PL

C

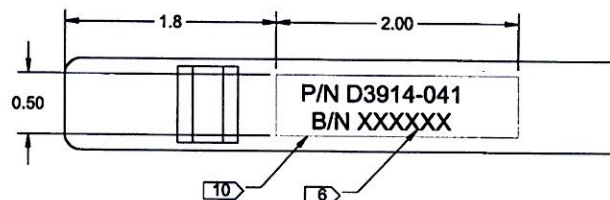
C



DETAIL D
SCALE 8X
3 PL

B

B



VIEW E-E
SCALE 8X

A

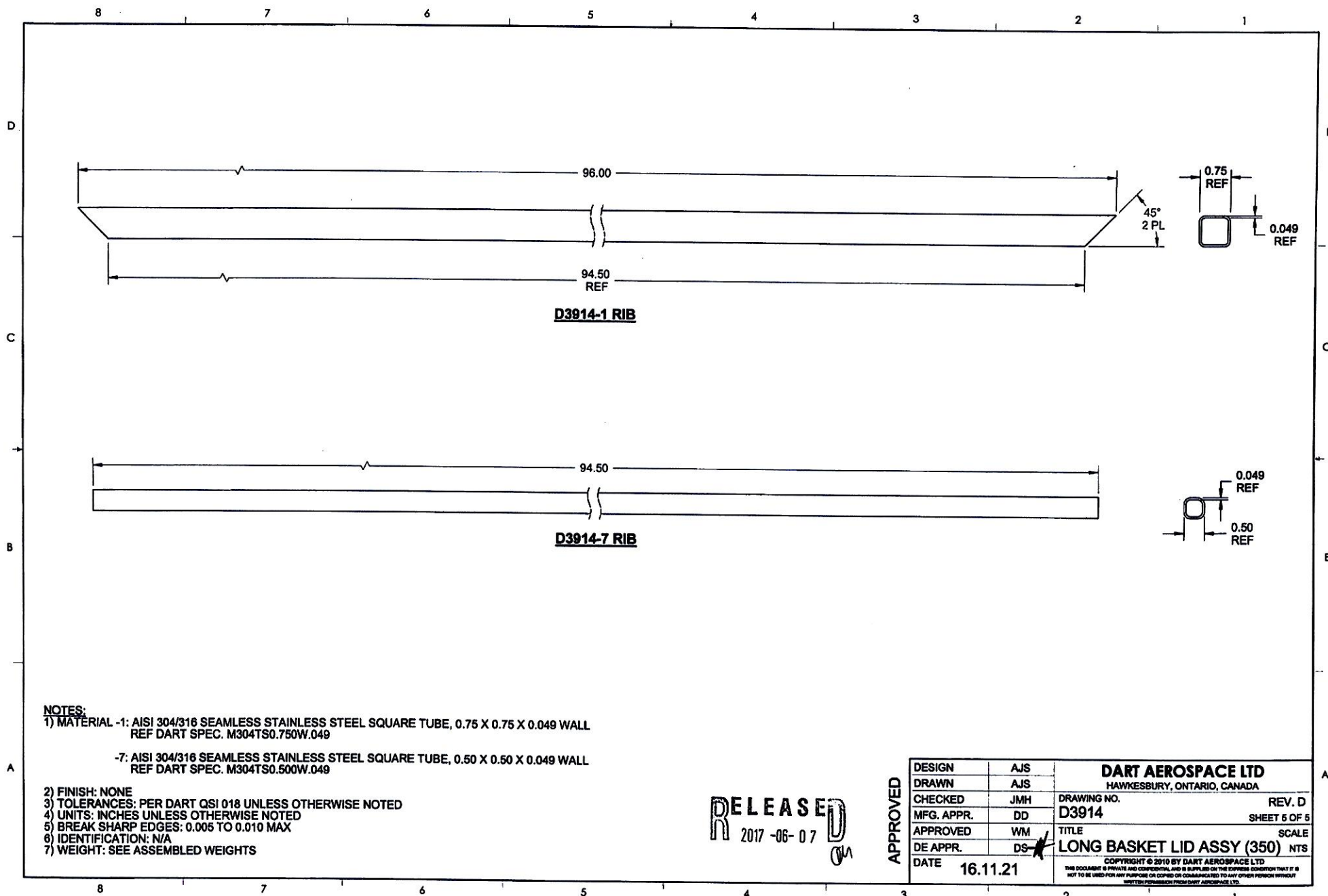
A

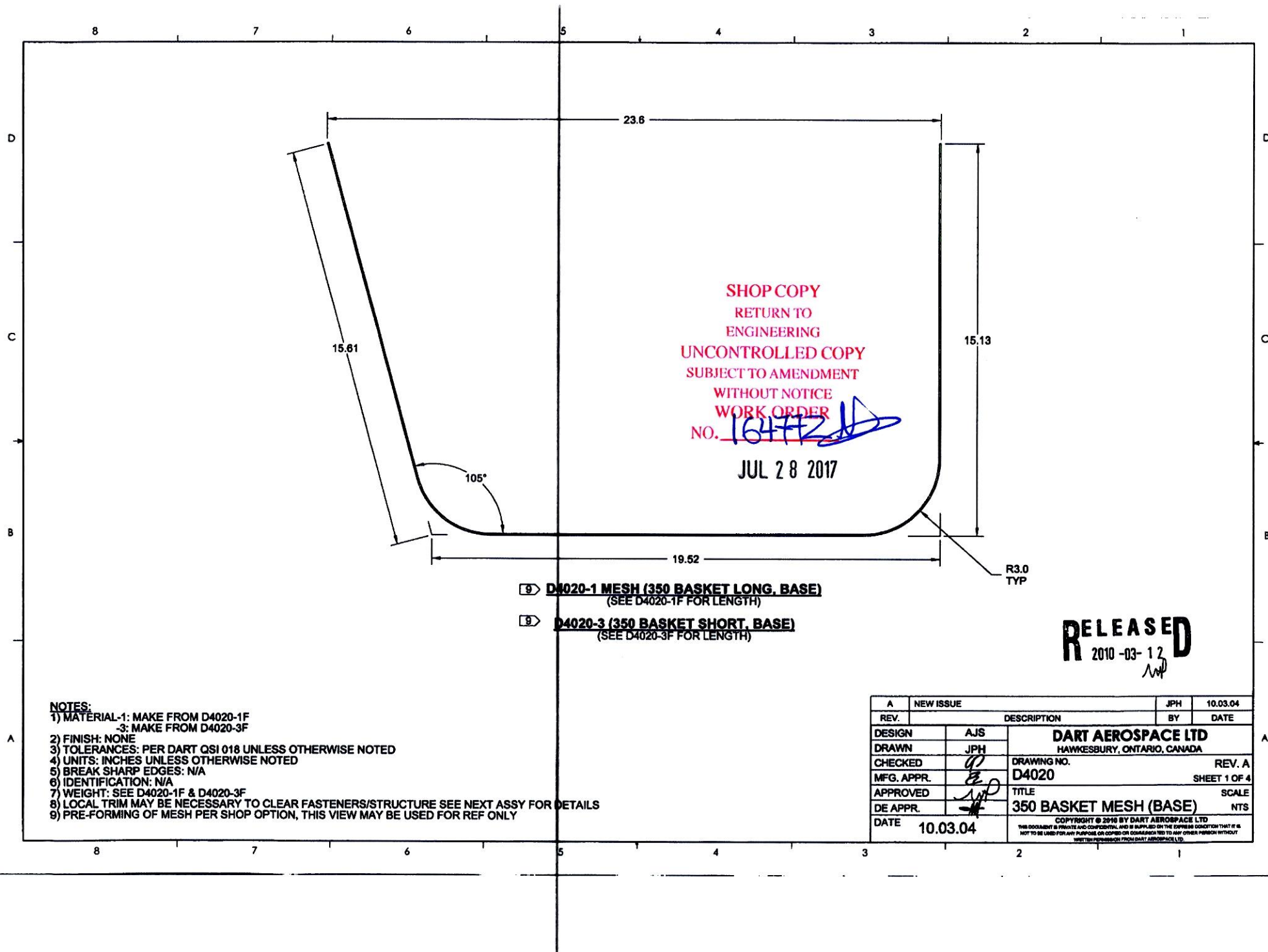
RELEASED
2017-06-07

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1





NOTES:

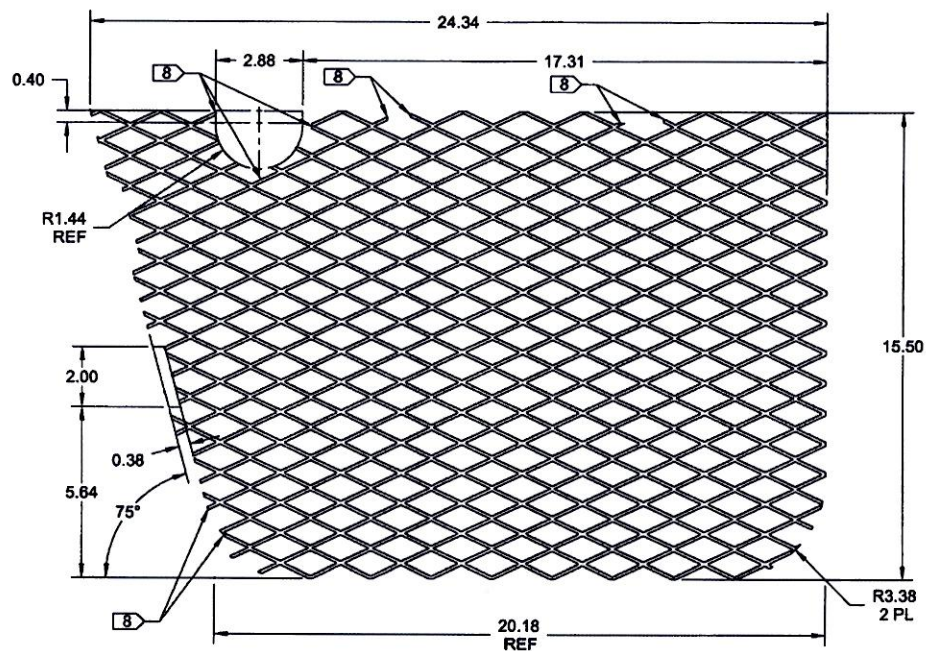
- 1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

- 9 D4020-1 MESH (350 BASKET LONG, BASE)
(SEE D4020-1F FOR LENGTH)
- 9 D4020-3 (350 BASKET SHORT, BASE)
(SEE D4020-3F FOR LENGTH)

A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	9		
MFG. APPR.	9		
APPROVED	9		
DE APPR.	9		
DATE	10.03.04		

RELEASED
2010-03-12

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D4020
REV. A
SHEET 1 OF 4
TITLE 350 BASKET MESH (BASE)
SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4020	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT			

